



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2892-1
Job Sheet 170527



Part No: D2892-1

Job Qty: 6 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 1/26/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified by: DD IPP Rev:E 11.08.04
as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining-1		FR 18-1-18
100	CNC Vertical Machining	6 pcs	1/25/18	1/25/18	0.36	5.08	HAAS1-2		77/SBL 18/01/20
120	QC	6 pcs	1/25/18	1/25/18	0.00	0.00	QC8		
130	Crosstubes	6 pcs	1/26/18	1/26/18	0.00	0.97	Crosstubes-2		AS 33 JAN 24 2018
140	QC	6 pcs	1/26/18	1/26/18	0.00	0.00	QC3		
170	Packaging	6 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-1	4605N	JAN 25 2018
180	QC21-SA	6 Ea	1/26/18	1/26/18	0.00	0.00	QC21		JAN 25 2018

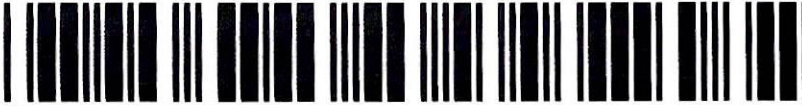
Part Op 100 - 1-Machine as per Folio FA082
Descriptions: 130 - Per note 8 on page 1 of dwg D2892, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg.
24h of cure time 138381 exp 18/11
170 - LOCATION : LG050

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	DSK077	3	3	0	0

DART
AEROSPACE
S033175

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Support

PART NO: D2892 – 1

Original Serial #: S033175

Revision:

Operation: Start up Operation 01/18/18

Change No:

Job No: 170527

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
2	2.250 Support	0.290Inches + 0.020 - 0.000	0.310 0.290		
3	2.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
4	2.250 Support	0.115Inches + 0.035 - 0.000	0.150 0.115		
5	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
6	2.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
7	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
8	2.250 Support	1.116Inches + 0.040 - 0.000	1.156 1.116		
9	2.250 Support	0.454Inches + 0.020 - 0.000	0.474 0.454		
10	2.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
11	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
12	2.250 Support	0.257Inches + 0.005 - 0.000	0.262 0.257		
13	2.250 Support	1.663Inches + 0.020 - 0.000	1.683 1.663		
14	2.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
15	2.250 Support	0.022Inches + 0.020 - 0.000	0.042 0.022		
16	2.250 Support	2.779Inches + 0.010 - 0.000	2.789 2.779		

DART AEROSPACE LTD		Work Order: 170 527
Description: Ø2.500 Support		Part Number: D2892-1
Inspection Dwg: D2892	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go #1 Gauge	2*	3*	4*	5*	6*
HAAS Section								
AA	0.115	0.150	.130	.130	.130	.180	.130	.130
AB	0.290	0.310	.300	.304	.300	.305	.300	.300
AC	0.040	0.060	.048	.050	.045	.045	.046	.047
AD	0.115	0.150	.125	.125	.125	.125	.125	.125
AE	0.240	0.260	.250	.250	.250	.250	.246	.245
AF	0.188	0.193	.189	.188	.189	.189	.189	.189
AG	0.240	0.260	.250	.250	.250	.250	.250	.250
AH	1.116	1.156	1.145	1.144	1.142	1.142	1.140	1.142
AI	0.454	0.474	.463	.463	.462	.463	.463	.464
AJ	0.240	0.260	.250	.250	.250	.250	.250	.250
AK	0.053	0.073	.063	.063	.063	.063	.063	.063
AL	0.257	0.262	.260	.260	.260	.260	.260	.260
AM	1.663	1.683	1.673	1.673	1.674	1.675	1.674	1.675
AN	0.053	0.073	.063	.063	.063	.063	.063	.063
AO	0.022	0.042	.032	.032	.032	.032	.032	.032
AP	2.779	2.789	2.784	2.782	2.782	2.783	2.783	2.783
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: SBL /ark	Date: 18/01/20
Audited by: P. 9	Date: 18/01/23
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.01.31	Dwg Rev updated	KJ	
D	13.05.22	Dimensions updated	KJ	MS